



Work Order ID 62168


Monday, September 20, 2010 10:14:50 AM


Page 1


Item ID:	D3684-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	MOUNT ASSEMBLY					
Start Date:	9/20/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/1/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>10-9-20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3684	Rev D								

100	Pick Kit	0.00							
									
Packaging	Memo	0.00		So	10/09/21	(1)			
Packaging									

110	Small Fab	0.00							
									
Small Fab	Memo	0.00				(1)			
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 □2-Assemble D3684-049 & D3687-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684□***Ensure holes for AN3C Bolts are free o			So	10/09/21				

120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00		So	10/09/21	(1)			
Quality Control	(Anti-seize on threads, k/b w/ D3688-5)								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3684-043

Accept

Setup Start

Revision ID:

Stop

Item Name: MOUNT ASSEMBLY

Start Date: 9/20/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/1/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: **B90**

0.00



Packaging

Memo

0.00

Packaging

01/12/05

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/23**ME**
10-9-23

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, September 20, 2010 10:14:49 AM

Parent Item: D3684-043

Parent Item Name: MOUNT ASSEMBLY





Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LJL
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	86.0000	4	4			
Bolts													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				86					
				112314				8					
				114761				11					
				115392				47					
				115594				20					
D3684-047 		Manufactured	No			110	Each	0.0000	1	1			
FWD LEG ASS'Y								B 62164					
D3684-049 		Manufactured	No			110	Each	0.0000	1	1			
AFT LEG ASS'Y								B 62165					
D3687-1 		Manufactured	No			110	Each	3.0000	1	1			
MOUNT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST075				3					
				61971				3					

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

Monday, September 20, 2010 10:14:49 AM

Work Order ID: 62168

Parent Item: D3684-043

Parent Item Name: MOUNT ASSEMBLY

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

D3692-1

 SPACER

Manufactured No

110 Each

349.0000 8 8



SS 10/09/21

Location

Loc Qty

Loc Code

ST082

349

51467

349

8

MS21043-3

Purchased No

110 Each

2,643.000 4 4



SS 10/09/21

Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2567

109147

4

111383

46

112314

2517

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

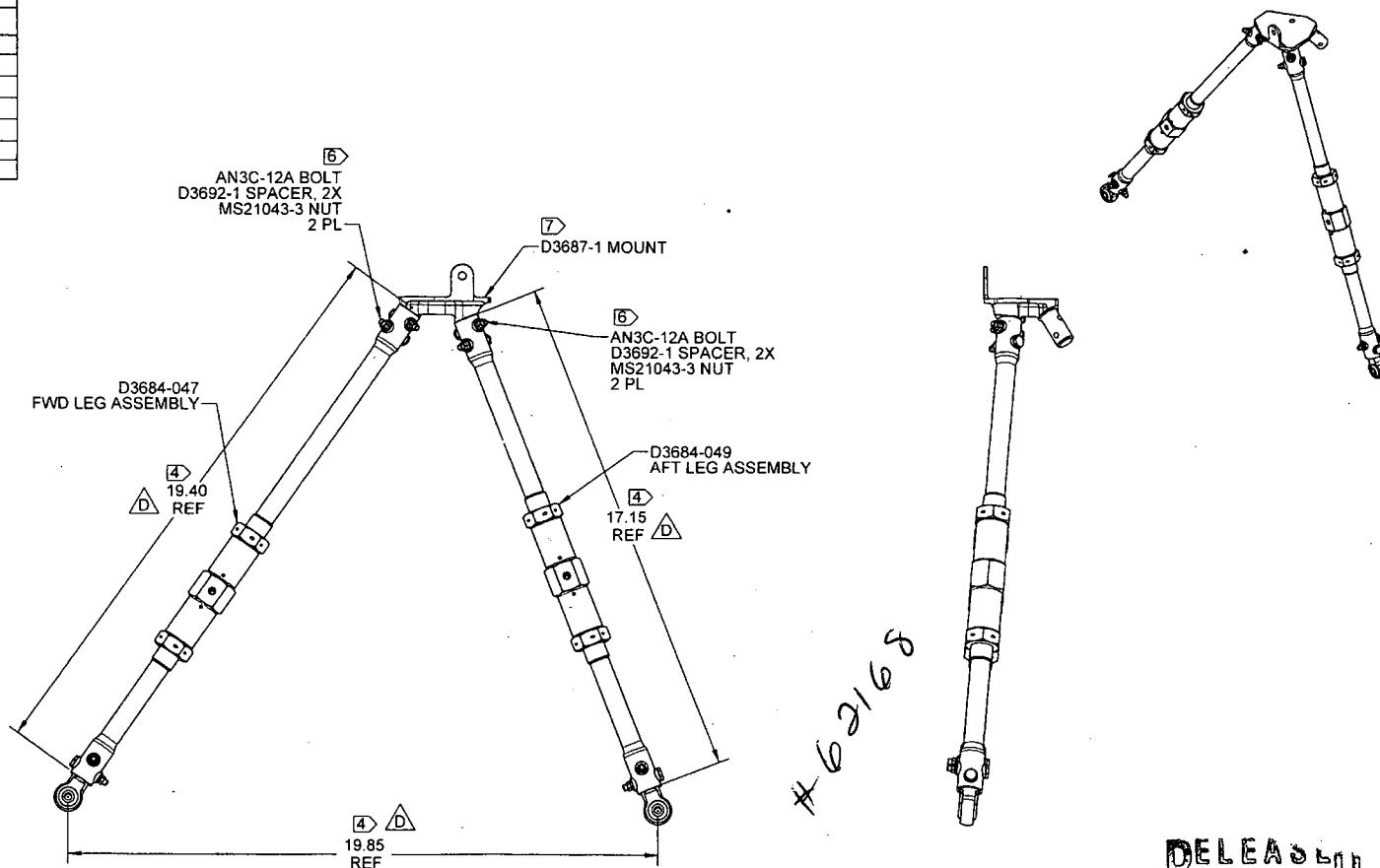
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASE
2010-03-15

W/O:		WORK ORDER CHANGES					
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